












Date: Thursday, 12/13/2007 2:42:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECAL
Job Number : 36335	
Estimate Number : 11164	
P.O. Number : <i>N/A</i>	Part Number : D32763
This Issue : 12/13/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 30916	Material : <i>N/A</i>
Written By : _____	Due Date : 12/20/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i> 02.12.13	
Comment : Est A 05.02.14 New issue KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	PG PURCHASING
 	
Comment: PURCHASING Issue P/O: <u>5281</u> <i>C207112114</i> (20) For D3276-3 decal as per Dwg D3276 Possible Supplier: Studio Lettrage Material release note is required	
2.0	D32763P Decal
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Decal	
3.0	PACKAGING 1 PACKAGING RESOURCE #1
 	
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>C 2/12/15 20</i>	
4.0	QC5 INSPECT WORK TO CURRENT STEP
 	
Comment: INSPECT WORK TO CURRENT STEP <i>5 7/12/20 (+70)</i>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 80</u> <i>[Signature]</i> <i>AS 7/12/20</i> x20	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 01/21/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:42:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECAL

Job Number: 36335

Part Number: D32763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

12/12/20

Job Completion



U 07.12.10

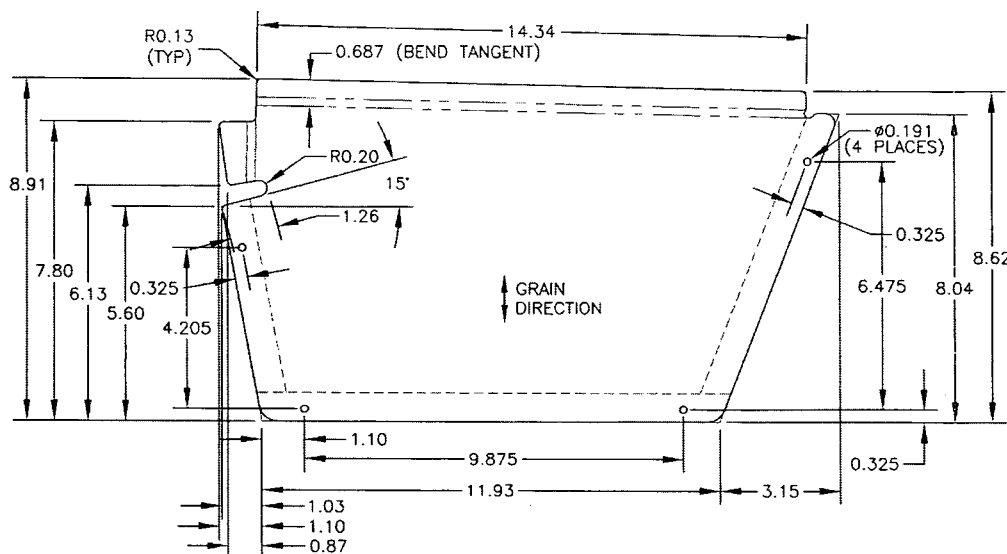
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

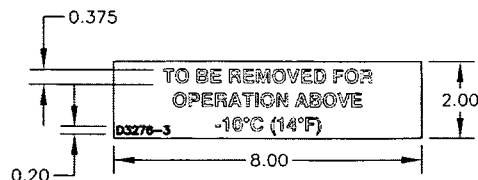
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3276-1 BAFFLE (FLAT PATTERN)

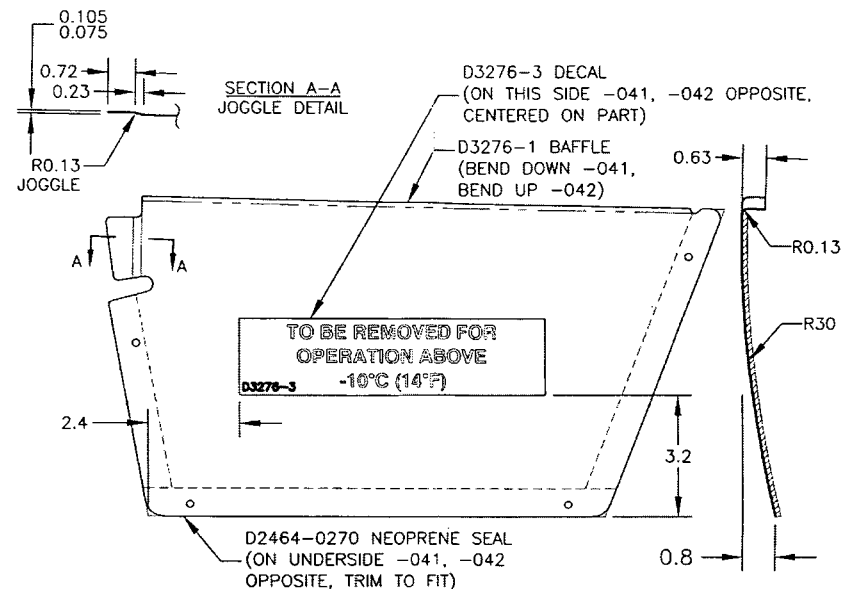
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 303335
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05.01.07

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B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	CP	DRAWING NO. D3276
DATE	05.01.25	TITLE BAFFLE ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE 1:3



PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

Avery Graphics™ A5 Opaque

5-year **INTERMEDIATE** calendared vinyl film

Dated: 10/3/02

Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendared vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendared vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68° - 77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss*: 70 at 60°

Avery Graphics™ A5 Opaque page 1 of 2

AnswerLine: 800-443-9380
Signage.averygraphics.com

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.² (91 cm²) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

Typical Converting Methods:

CUTTING

Computer Sign Cutting: yes

Angle of Blade: 30° or 45°

Minimum letter Height: 0.5 inch

PRINTING

Thermal Transfer Printing: yes

Ink Jet Printing: no

E-Stat printing: no

Screen Printing: no

Exceptions:

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°

Pigmented Adhesive Exceptions: none

** Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTIES: All of claims for technical information and performance statements about Avery Dennison products is based upon tests believed to be reliable and do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year or the period stated on the specific product information literature in effect at time of delivery. If longer term date of shipment is used product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product at Avery Dennison's election, and in the event replacement or repair is not commercially practical, to Avery Dennison's giving Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid hereunder by Purchaser and in no event shall Avery Dennison be responsible for any consequential or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damages are caused by Avery Dennison's negligence.

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DART

Purchase Order

Date Dec 14, 2007	Page 1
Purchase Order Number PO00005281	

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
667019

Vendor Address:

Studio de Lettrage 2001
210 Main West
Hawkesbury, ONT K6A 2H6
Canada
Phone (613) 632-5449
Fax (613) 632-9491

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-STU001	PO Date Dec 14, 2007	Terms N30	Ship Via yours	Expected Arrival Dec 19, 2007
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
20.0000	D32763P ✓	Decal Comments: AS PER DWG D3276 REV. B RED LETTERS ON WHITE ADHESIVE BACK MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 B36335	12/19/2007	No	10.000000	Each	200.00
<div>CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY</div> <div>FOR EXPORT ONLY my BAD 6/12/20</div> <div>REFERENCE ONLY</div> <div>REFERENCE ONLY</div>							
Comments:		Tax Summary: GST 12.00 GSTME 0.00 GSTND 0.00			Less: included tax 0.00 Subtotal 200.00 Total tax 12.00 Total purchase order in CAD Dollars 212.00		
Entered By: CL CLAVOIE		Approved By: 